

Date: Thursday, 12/20/2007 3:17:30 PM  
 User: Kim Johnston

## Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
 Job Number : 36467A03  
 Estimate Number : 10145  
 P.O. Number : N/A Part Number : D2037101  
 This Issue : 12/20/2007 S.O. No. : N/A Drawing Number : D2037 REV C3  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : C3  
 Previous Run : 36466A03 Material : N/A  
 Due Date : 1/15/2008 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : J.D. 12/21  
 Comment : Est Rev: A New Issue 05-11-01 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0750W049 304 RD Tube .750 x .049W



Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s)  
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)  
 Batch: M106015x3 / M105980x1 FF 10-01-08 (4)

2.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1 FF 10-01-08 (4)

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037 FF 11-01-08 (4)

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required FF 14-01-08 (4)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP 08/06/15 (4)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 241A 8/1/15 (4X) SP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/04/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: ARM

Job Number: 36467A03

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

2008/01/16

Job Completion



u 28-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

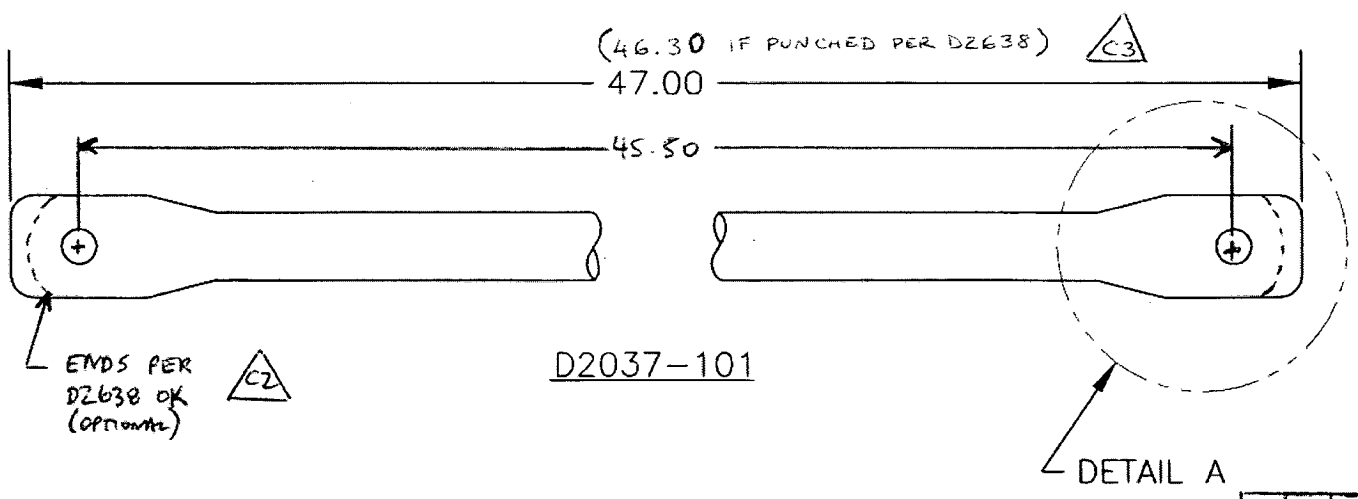
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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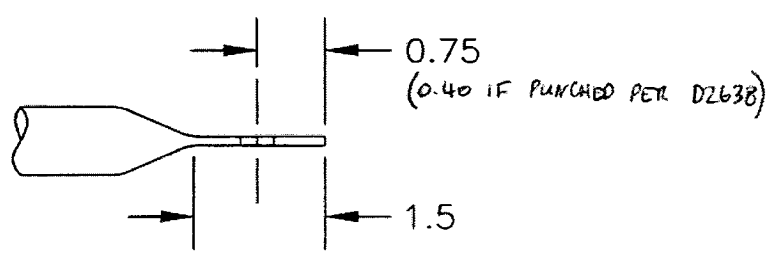
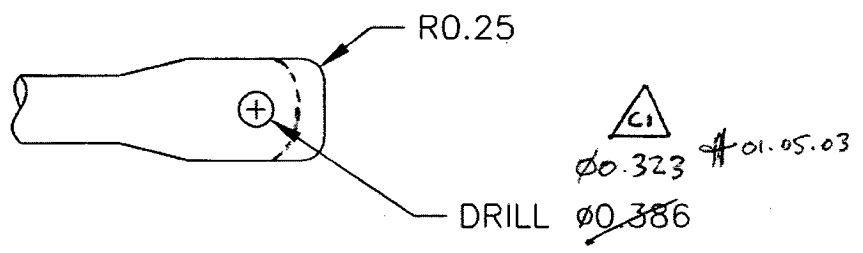
NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	RF	DRAWING NO. D2037
DATE	99.06.07	TITLE	ARM	REV. C SHEET 1 OF 1
A		91.10.22	NEW ISSUE	SCALE NTS
B		93.04.20	-103 DELETED	
C		99.06.07	REDRAWN, 0.386 WAS 0.375	
C1		01.05.03	CHANGE TO $\phi 0.323$	
C2		02.06.14	ADD PUNCH PER D2638 AS APPROV	



D2037-101



DETAIL A

RELEASED  
RE 99.06.10

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 264617A03

C3 05.04.27 ADD 46.30 PUNCHED PER D2638